

Date: Friday, 04/04/2008 9:22:18 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	DOUBLER
<b>Job Number</b> :	38405		
<b>Estimate Number</b> :	10775		
<b>P.O. Number</b> :		<b>Part Number</b> :	D32081
<b>This Issue</b> :	04/04/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3208 REV A1
<b>First Issue</b> :	/ /	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	36536	<b>Drawing Revision</b> :	A1
	<b>Type</b> :	<b>Material</b> :	
	MACHINED PARTS	<b>Due Date</b> :	14/04/2008
<b>Written By</b> :		<b>Qty:</b>	20
<b>Checked &amp; Approved By</b> :	JVL 08-04-4	<b>10-Um:</b>	Each
<b>Comment</b> :	Est: B04.05.25 Material changed for Step 4KJ/JLM		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M2024T3S040	2024-T3 .040 sheet
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**Comment:** Qty.: 0.1727 sf(s)/Unit Total: 1.7273 sf(s)  
 Material: 2024-T3 (QQ-A-250/4) 0.040" thick  
 (M2024T3S.040)  
 Note: To be made in multiples of 10  
 Batch: M107572

CB 08/04/07 (20)

2.0	SHEAR	SHEAR
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**Comment:** SHEAR  
 Cut blank: 4.038" X 5.340" grain along 4.038"  
 Identify for D3208-1

CB 08/04/07 (20)

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1  
 Drill and Fillet D3208-1 corner as per Dwg D3208  
 Identify as D3208-1

CB 08/04/07 (20)

4.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE  
 Deburr D3208-1  
 Form D3208-1 as per Dwg D3208  
 Polish any marks on part within 01. of Dwg D3208

CB 08/04/07 (20)

08/04/08  
 CB 08/04/09 (19)

(19) PT 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3208-1 PAR #: N/A Fault Category: Prod / Process med & small NCR: Yes No DQA: D Date: 08/04/15  
 (D412-704-011) QA: N/C Closed: D Date: 08/04/15

NCR: <u>38405</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/04/08	4	1 piece was snap out of tolerance  Re-Home error at the set up Part was Bent 4.038" knob was	<i>[Signature]</i> 08/04/08	Scrap + destroyed no replace	<i>[Signature]</i> 08/04/08	<i>[Signature]</i> 08/04/09	<i>[Signature]</i> 08/04/09	<i>[Signature]</i> 08/04/09

NOTE: Date & initial all entries

Date: Friday, 04/04/2008 9:22:18 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 38405

Part Number: D32081

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*S. 08/04/09* (19)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*FJ 08/04/09* (19)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

*M-h 08/04/09* (19K)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *STW*

*P. 08/04/09* (19)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/04/14*

Job Completion



*MF 08-04-10*

*W*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

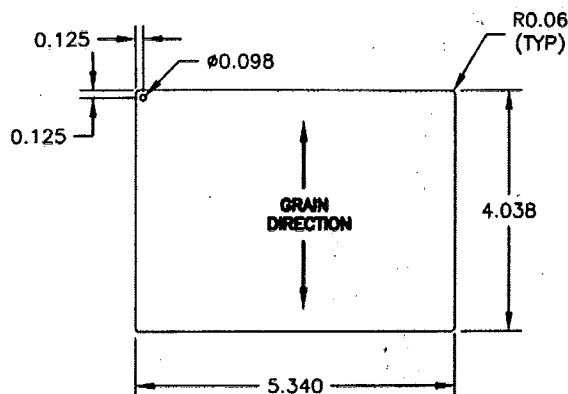
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

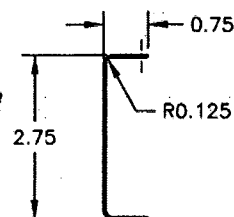
**DART**

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DATE 04.01.27		TITLE DOUBLER	SCALE 1:3
A	04.01.27	NEW ISSUE	
AI	# 04.05.25	CHANGE DIM; NOTE 3) CHANGE	

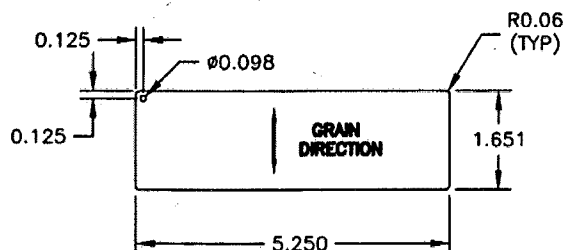
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04.04.05 #



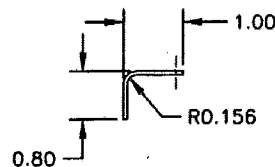
2 D3208-1 DOUBLER  
FLAT PATTERN



D3208-1 DOUBLER  
BEND DETAIL



3 D3208-3 PEDAL MOUNT ANGLE  
FLAT PATTERN



D3208-3 PEDAL MOUNT ANGLE  
BEND DETAIL

**NOTES:**

- 1) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040" THICK (M2024T3S.040)
- 3) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063" THICK (M2024T3S.063)
- 4) MATERIAL: 2024-T3 (QQ-A-250/4) 0.080" THICK (M2024T3S.080)
- 5) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES
- 3) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063" THICK (M6061T6S.063)

AI

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WORK ORDER  
NO. 38405

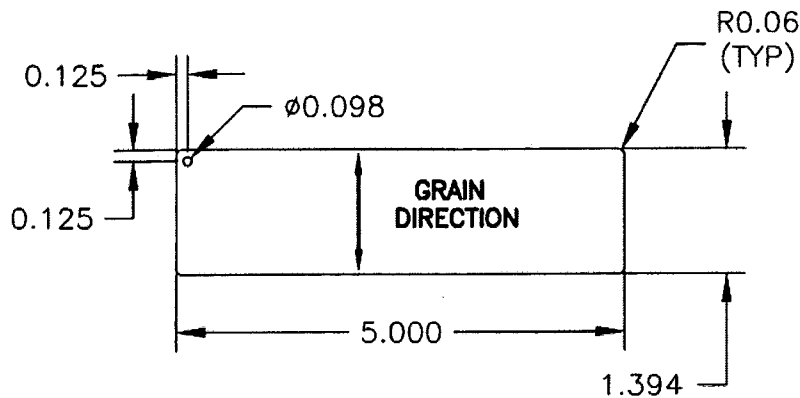
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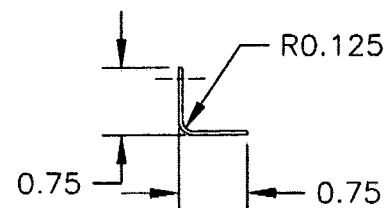


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DATE 04.01.27		TITLE DOUBLER	SCALE 1:2

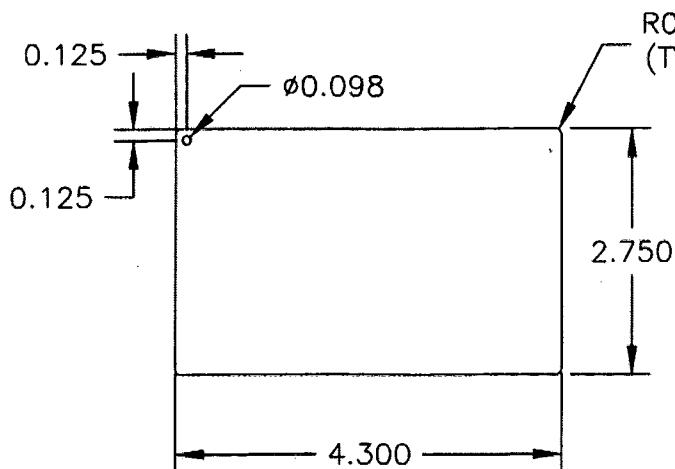
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04.04.05



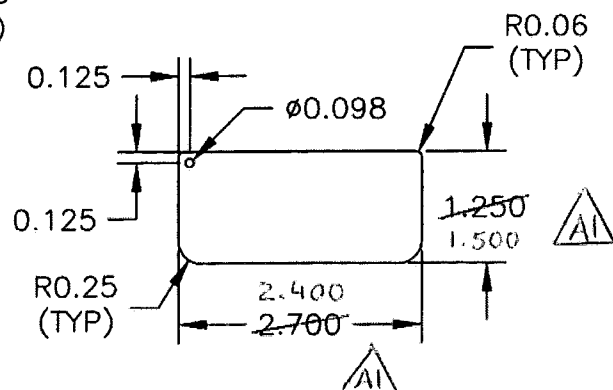
2 D3208-5 MOUNT ANGLE  
FLAT PATTERN



D3208-5 MOUNT ANGLE  
BEND DETAIL



2 D3208-7 FILLER



2 D3208-11 FILLER

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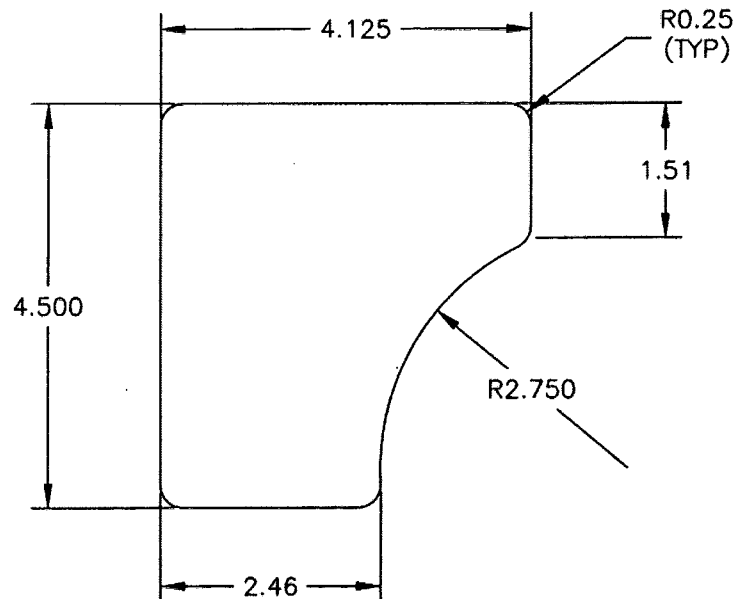
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DATE 04.01.27		TITLE DOUBLER	SCALE 1:2

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04.04.05 [Signature]



**D3208-9 DOUBLER**

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